

Work Order ID 165526

Friday, August 25, 2017 10:11:39 AM

165526

Ship 7 Sept

Page 1

Item ID: D5061-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Wearplate

Start Date: 8/25/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/5/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: **AUG 25 2017** Tooling: _____ Date: _____
QC: 9-88 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5061	A								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.61							
FLOW CNC Waterjet	1- Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.04							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.08							
Quality Control									

(4)

08/17/08/26

(4)

08/17/08/26

4

Dwg
38
9-88

AUG 29 2017

Work Order ID 165526

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Page 2

Item ID: D5061-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Wearplate
Start Date: 8/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/5/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	Form as per dwg NC BRAKE Memo Form joggle as per dwg.	0.96 0.77			DAS 30 9-89	(4)			AUG 31 2017
150 *150* QC Quality Control	QC6- All purchased or subcontracted products Memo	0.00 0.00				4			DAS 38 9-89 AUG 31 2017
160 *160* Large Fab Large Fab	Large Fab Memo Weld hard surface as per OSI 004 and Dwg D5061 2059 Hardcoat Rod	0.00 1.04				(4)			DYC/O.L 17/09/05

Work Order ID 165526***165526***

Page 4

Friday, August 25, 2017 10:11:39 AM

Item ID: D5061-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Wearplate
Start Date: 8/25/2017 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 9/5/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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186

QC3- Inspect Part Finish

0.00

186

QC

Memo

0.04

Quality Control

④ 17-09-07 PD

190

Identify as per dwg & Stock Location: _____

0.00

190

Packaging

Packaging

Memo

0.04

Packaging

fp 002y Smb 17/9/17

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.40

Quality Control

17/9/1721
P.06

SEP 07 2017

Picklist Print

Friday, August 25, 2017 10:11:43 AM

Page 1

Work Order ID: 165526

165526

Parent Item: D5061-1

D5061-1

Parent Item Name: Fwd Wearplate

Start Date: 8/25/2017

Required Date: 9/5/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 14.02.13 NEW ISSUE DD VERF:JLM IPP
REV:B 14.03.12 rev.A10 DD VERF:JLM IPP REV:c
14.04.21 rev.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA		Purchased	No			110	sf	144.5199	3.58	15.07368			
-----------	--	-----------	----	--	--	-----	----	----------	------	----------	--	--	--

M304S18GA

304/316 .050 Sheet

**

217/08/26

Location

Loc Qty

Loc Code

MAT020

143.7159

M135779

7.02

M136036

4.65

M136568

12.6959

M136687

2.24

M136790

9.74

M137481

24.5

M137980

18.87

M138346

64

MAT20

0.804

M134580

0.804

11.5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

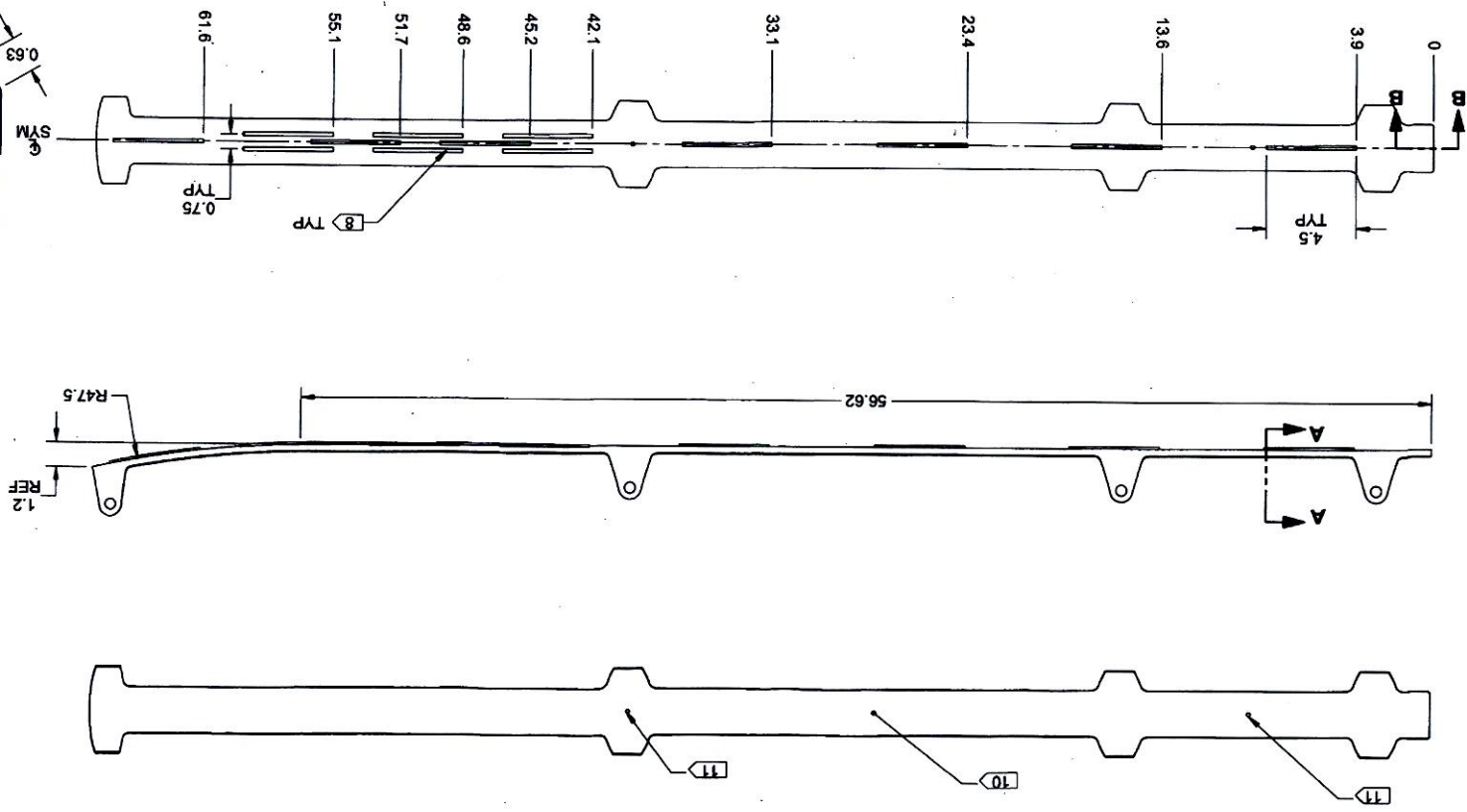
QA Closed: _____ Date: _____

Work Order update only ☐

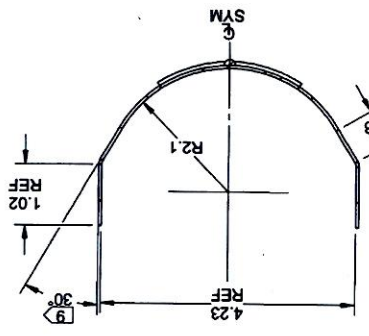
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

- NOTES:
- 1) MATERIAL: MAKE FROM D5061-1F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 3.0 lbs
 - 8) WELDING: PER QSI 004, APPLY LAYER OF 2059 HARDCOAT WELD TO 0.063 - 0.125 HIGH AFTER BENDING
 - 9) IT IS ACCEPTABLE TO OVERBEND UP TO 2 DEGREES OR UNDERBEND UP TO 5 DEGREES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THK, PER QSI 005 4.9
 - 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING TEXTURED COATING

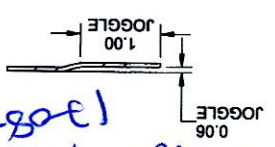
D5061-1 FWD WEARPLATE
(MAKE FROM D5061-1F)



SECTION A-A
SCALE 3X



SECTION B-B
SCALE 3X



APPROVED

DESIGN	AP
DRAWN	AJS
CHECKED	AP
MFG. APPR.	DD
APPROVED	MP
DE APPR.	D9
DATE	14.04.08

DART AEROSPACE LTD
DRAWING NO. **D5061**
REV. A
SHEET 2 OF 5
SCALE
NTS
HAWKESBURY, ONTARIO, CANADA

RELEASED
2014-04-15
MD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165526 M.C.
1308-21

DQA: _____ Date: _____

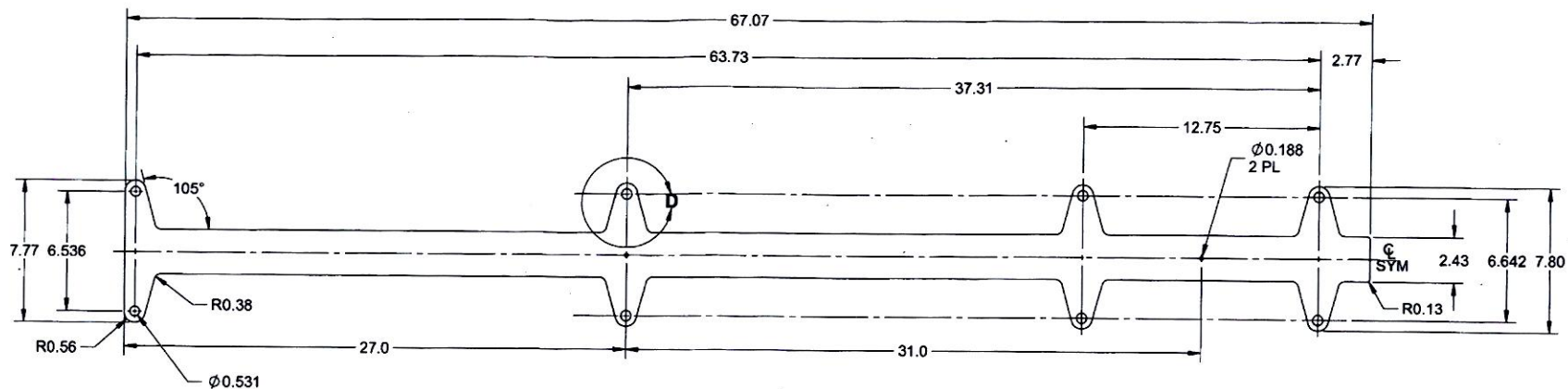


WORK ORDER NON-CONFORMANCE / UPDATE

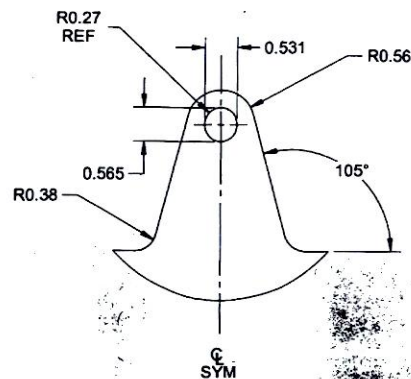
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			



D5061-1F FWD WEARPLATE



DETAIL D
SCALE 3X
3 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

RELEASED
2014-04-15

APPROVED	DESIGN	AP	DART AEROSPACE LTD	
	DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AP	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5061	SHEET 4 OF 5
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	WEARPLATE	NTS
	DATE	14.04.08		COPYRIGHT © 2014 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				

DQA: _____ Date: _____



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Work Order update only ☐

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OTHER : _____					